

Work Order ID 54832

December 22, 2009 2:17:27 PM

Page 1

Item ID: D350-588-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00

Required Date: 1/22/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: CZ Date: 09/12/22 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

*S. 10/3/02**D. 10/03/02*

110

0.00



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 11005 Description: D2445 Baggage Door Supplier:
Delastek Ship to Delastek (1) D0588-041 label Certification of Conformity
and process sheet from Delastek is required.*CZ 09/12/22**①*

120

0.00



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Ensure Certificate of Conformity & Process Sheet are attached

P. 10/2/02

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Stop

Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00

Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC6- Inspect dimensions to drawing

0.00

8/10/22

(X)

Pho →

QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445. □ Audit process sheet.

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

RT

10-02-24

(X)

150

QC5- Inspect part completeness to step on W/O

0.00

8/10/24

(X)

QC

Memo

0.00

Quality Control

W/O: 54832

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/23	1	Perm. change Missing parts from w/o to parts list. ADD missing parts - 1 square ft. of 902 glass cloth B# <u>M111666</u> +1 - 10696-17 B <u>50666</u> x1	SE	10/3/23			S 10/02/23
		- Fix w/o + Bom. ADD copy of new updates Bom for ref. also FIX Routing numbers	AA	10.03.03			S 10/02/23

Part No: D350-588-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC4- 100% Inspect kits for completeness

0.00

Subtotal



QC

Memo

0.00

Quality Control



170

Identify as per dwg & Stock Location: MEV: 0

0.00



Packaging

Memo

0.00

Packaging

P10/3/12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03
MF 10-3-2

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Work Order ID: 54832

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NS26C1032R7 Screw		Purchased	No				Each	136.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	136	
104394	3	
113064	100	
113096	33	

10-3-2 SP

NS26C632R8 Screw		Purchased	No				Each	312.0000	8.0000			
---------------------	--	-----------	----	--	--	--	------	----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	312	
2405	312	

10-3-2 SP

8

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Work Order ID: 54832



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R9		Purchased	No				Each	229.0000	8.0000			
Screw												

10-02-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	229	
107376	51	
108377	5	
108928	14	
110372	8	
110915	1	
111916	1	
112492	149	

B 113595

x 8

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Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
960JD10 Washer		Purchased	No				Each	1,486.000	2.0000			

Washer

7AS1149003631

651 017

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1486	
105442	8	
109059	2	
109840	23	
110139	2	
110985	202	
111279	5	
111668	48	
112314	174	
112369	22	
113149	1000	

1113288 10-3-25

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Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No				Each	1,486.000	2.0000			

Washer

QSI OR
NAS1149 D03632

21 10-02-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
• ST	1486	•
105442	8	
109059	2	
109840	23	
110139	2	
110985	202	
111279	5	
111668	48	
112314	174	
112369	22	
113149	1000	

113288

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Parent Item Name: Aft Door Assembly

Comments:


Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD8		Purchased	No				Each	1,217.000	8.0000			
  12385 ST 10-02-23												
Washer												

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	1217	
107091	9	
108335	11	
110382	48	
110917	3	
111578	60	
112314	366	
112385	720	

AN960JD8		Purchased	No				Each	1,217.000	16.0000			
  10-3-2 5												
Washer												

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	1217	
107091	9	
108335	11	
110382	48	
110917	3	
111578	60	
112314	366	
112385	720	

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Work Order ID: 54832

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Comments:

Start Date: 12/22/09



Required Date: 1/22/10

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2143  Hinge Bracket		Manufactured	No				Each	29.0000	1.0000 		<i>RT 10-02-23</i>	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	29*	
37739	29	

D2144  Hinge Bracket		Manufactured	No				Each	14.0000	1.0000 		<i>RT 10-02-23</i>	
--	--	--------------	----	--	--	--	------	---------	---	--	--------------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
41174	14	

<i>46</i> D2150  Packer Doubler, Hinge		Manufactured	No				Each	16.0000	2.0000 		<i>BSS016 10-3-25</i>	
--	--	--------------	----	--	--	--	------	---------	---	--	-----------------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
45813	16	

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Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2151  Packer Doubler, Hinge		Manufactured	No				Each	60.0000	2.0000			
--	--	--------------	----	--	--	--	------	---------	--------	--	--	--

10-3-2 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

*ST

60


51407

60

Each

34.0000

1.0000

D2153

Door Prop

Manufactured No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

34

48373

34

Each

29.0000

1.0000

D2154

Stud Bracket

Manufactured No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

29

44890

19

45814

10

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Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2237 Manufactured No

Each 64.0000 2.0000



Striker Plate



BS5006 10-3-2 sl

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST 9

46162 9

Main Warehouse

ST022 55

52327 55

D2461 Manufactured No

f 170.7040 7.2500



Neoprene "D" Seal



10-3-2 sl (14)

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST 170.7039842

34304 14.234

39782 156.469984

10-3-2 sl

x1 #87" long
↳ measure
81067/02

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Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2463		Manufactured	No				f	577.1626	7.2500			
-------	--	--------------	----	--	--	--	---	----------	--------	--	--	--



Seal



RT 10-02-24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

75.3752

31350

1.8278

34305

18.25

41121

3.75

43841

51.5474

Main Warehouse

ST404

501.7873684

50075

501.787368

D2585

Manufactured No

Each

90.0000

2.0000



Mounting Channel



RT 10-02-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

64

45888

4

53798

60

Main Warehouse

ST37

26

51526

26

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Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2586  Door Latch		Manufactured	No				Each	89.0000	2.0000			

RT 10-02-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

89

45554

1

47183

2

50213

86

x2

D2589

Manufactured No

Each

56.0000

1.0000

B47183 10-3-2 sf

C-2-32-25

Warehouse Loc Qty Loc Code

Location

HONG KONG

ST

1

46840

15

46846

1

50378

40

D2621

Manufactured No

Each

66.0000

2.0000

RT 10-02-23


Latch Plate, 350 Spacepod

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

66

46842

66

x2

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Work Order ID: 54832



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2857-1		Manufactured	No				Each	29.0000	1.0000			
Hinge Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	29	
41166	7	
45788	4	
50235	6	
<u>53464</u>	12	

ST 10-02-23

D2857-2		Manufactured	No				Each	25.0000	1.0000			
Hinge Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	25	
45797	13	
<u>53465</u>	12	

ST 10-02-23

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Work Order ID: 54832

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2858-1		Manufactured	No				Each	27.0000	1.0000			
---------	--	--------------	----	--	--	--	------	---------	--------	--	--	--

Hinge Bracket

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	27	
	43364	3	
	45798	24	

D2858-2		Manufactured	No				Each	19.0000	1.0000			
---------	--	--------------	----	--	--	--	------	---------	--------	--	--	--

Hinge Bracket

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	19	
	41439	4	
	45799	15	

MS20426AD3-4		Purchased	No				Each	7,765.000	12.0000			
--------------	--	-----------	----	--	--	--	------	-----------	---------	--	--	--

RIVET

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	7765	
	104374	3765	
	110398	4000	

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Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD4-5

Purchased

No

Each

2,485.000

8.0000



Rivet, Universal Head

10-3-2 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2485

109031

6

111916

2479

Each

453.0000

10.0000

MS21042L08

Purchased

No



Nut

10

m113749 10-3-2 sf (10)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

453

110002

24

111889

30

112243

43

112492

24

112612

1

112794

31

113149

100

113226

200

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Start Qty: 1.00

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MS21042L08 Nut		Purchased	No				Each	453.0000	8.0000			
										RT 10 02-23		

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	453	
110002	24	
111889	30	
112243	43	
112492	24	
112612	1	
112794	31	
113149	100	
113226	200	

B113595

MS21042L3



Nut

Purchased No

Each

2,372.000

2.0000



10-2-2

SP

10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2372	
110844	35	
111274	27	
111668	64	
112314	1746	
112385	500	

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Comments:

Start Date: 12/22/09

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No				Each	2,372.000	4.0000			

ST 10-02-23

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	2372	
110844	35	
111274	27	
111668	64	
112314	1746	
112385	500	

MS27039-08-11

Purchased

No



Screw

Each 76.0000

6.0000



84
10-3-2 sl 10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	76	
111977	76	

2

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Start Date: 12/22/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15		Purchased	No				Each	163.0000	2.0000			

Screw

ST 10-02-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	163	
106903	3	
108169	4	
109321	4	
111916	52	
<u>112794</u>	100	<u>x2</u>

D24457 purchased

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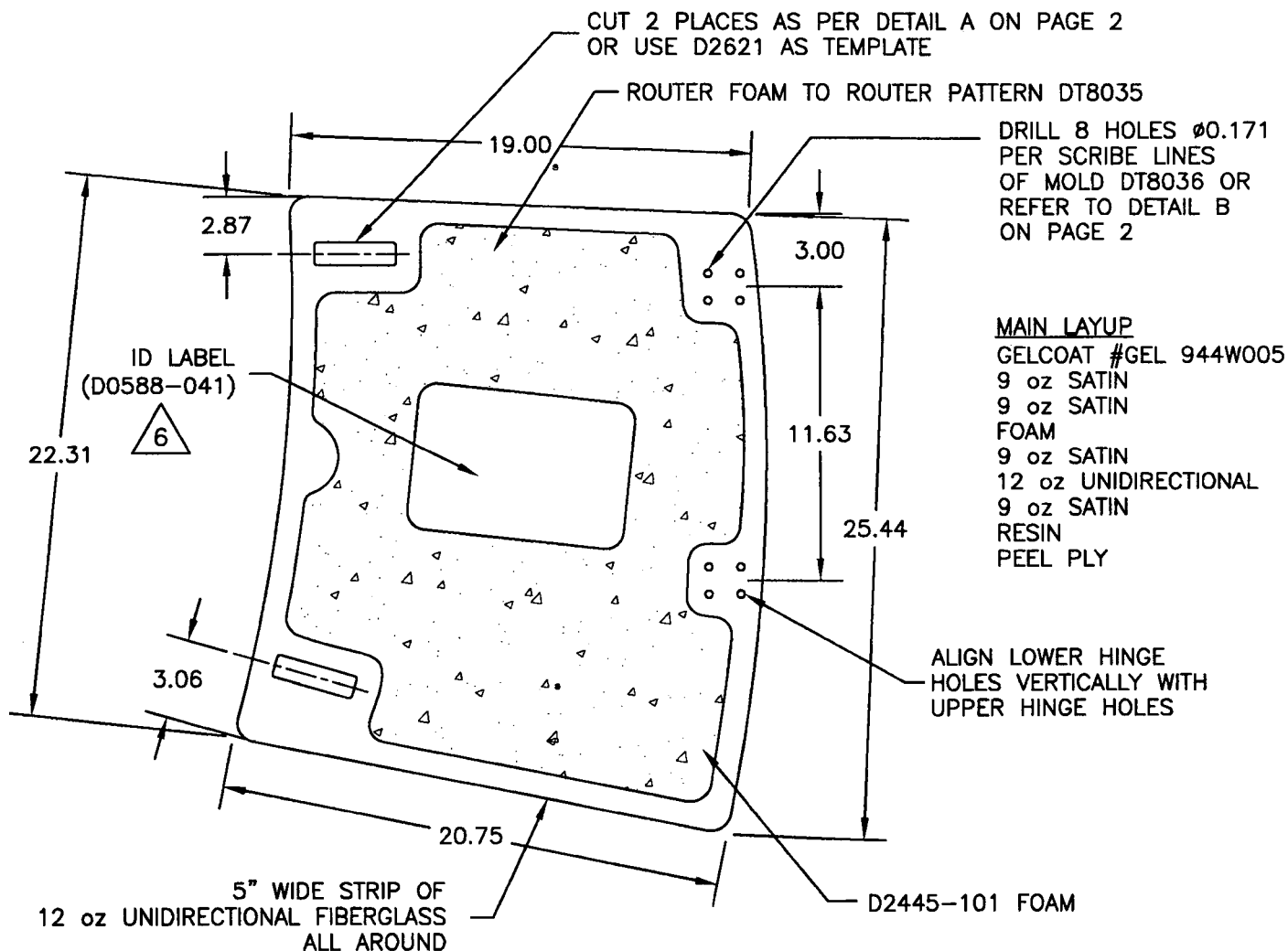
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13



NOTES:

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYLCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

C209112/22

W/O: 54832

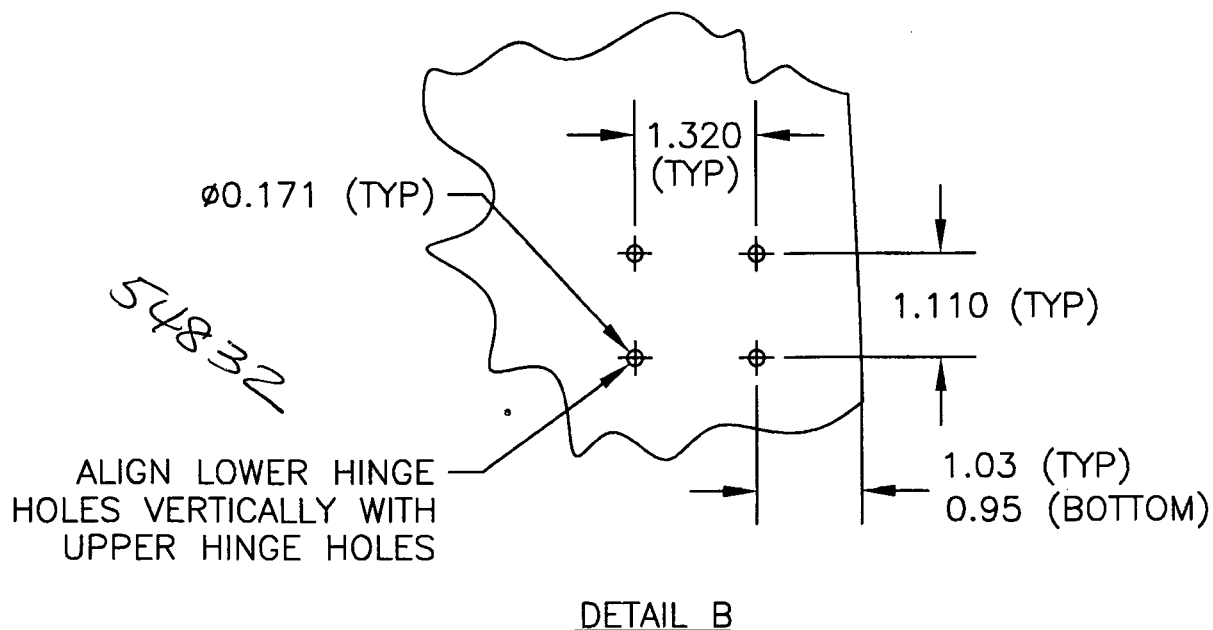
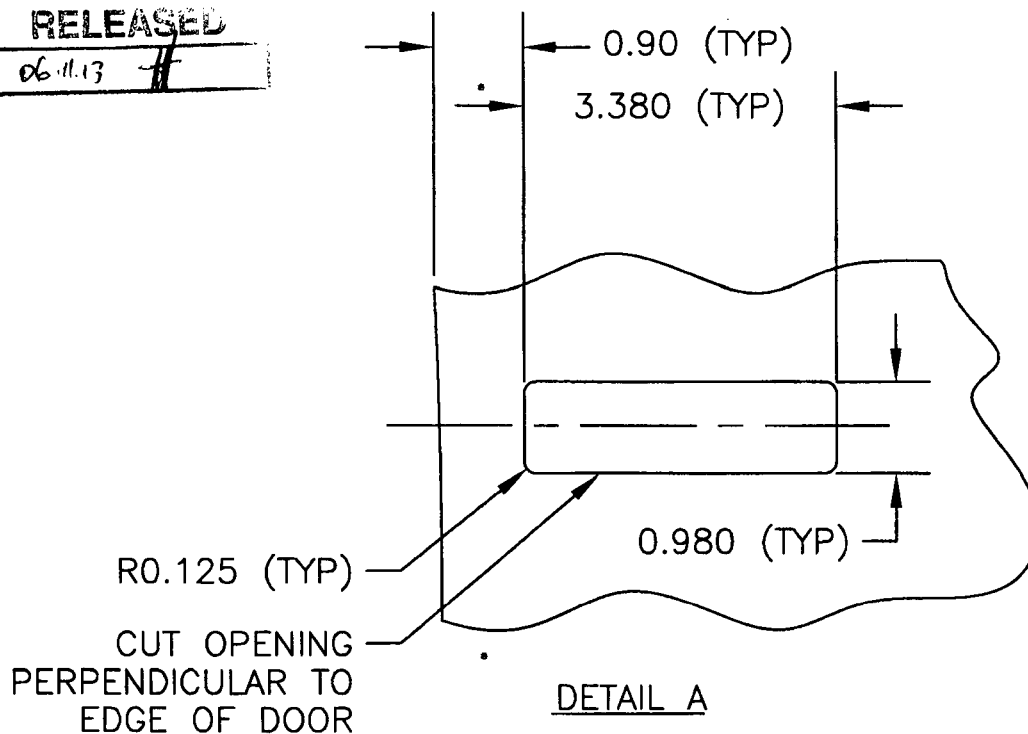
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
①	1	D2143	HINGE DOUBLER <i>install</i>
①	1	D2144	HINGE DOUBLER <i>install</i>
2	2	D2150	HINGE PACKER <i>kit</i>
2	2	D2151	HINGE DOUBLER <i>kit</i>
1	1	D2153-3315-10	GAS SPRING ASSY. <i>kit</i>
1	1	D2154	STUD BRACKET <i>kit</i>
2	2	D2237	STRIKER PLATE <i>kit</i>
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL <i>install</i>
①	1	D2463-0870	1/2" FOAM SEAL <i>install</i>
	2	D2583	LATCH BRACKET
②	2	D2585	LATCH CLAMP <i>install +2</i>
②	2	D2586	LATCH <i>install</i>
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN <i>/</i>
②		D2621	LATCH PLATE <i>install</i>
1	1	D2690-17	CABLE, DOOR STOP <i>kit</i>
①	1	D2857-1	LOWER HINGE BRACKET <i>install</i>
①	1	D2857-2	UPPER HINGE BRACKET <i>install</i>
1	1	D2858-1	LOWER HINGE BRACKET <i>kit</i>
1	1	D2858-2	UPPER HINGE BRACKET <i>kit</i>
2	3	AN526C832R8	SCREW (or AN526-832R8) <i>kit</i>
③	8	AN526C832R9	SCREW (or AN526-832R9) <i>install</i>
2	2	AN526C1032R7	SCREW (or AN526-1032R7) <i>kit</i>
②	24	AN960JD8	WASHER <i>(-2) 25 in kit</i>
4	4	AN960JD10	WASHER <i>-2 kit</i>
12	12	MS20426AD3-4	RIVET <i>kit</i>
18	18	MS20470AD4-5	RIVET <i>kit</i>
②	18	MS21042L08	NUT (or MS21042-08) <i>(-2) 10 x kit</i>
②	4	MS21042L3	NUT (or MS21042-3) <i>+2 install -2</i>
②	2	MS27039-1-15	SCREW <i>install</i>
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13310
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
04/02/2010	06/01/2010	6081	Chantal Lavoie		PO11005		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B54832 U de M : Each Drawing N° : D2445 Rév.: D Job: 43644 8/10/02/02			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357



Date: Lundi, 2009-02-09 08:10:45
 Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : AFT BAGGAGE DOOR D2445
Numéro Job : 43644		Numéro Article : DKC134-0013
Numéro Soumission : 2017		Numéro Dessin : D2445
Numéro B.A. :		Projet Numéro : DKC134
Cette fois : 2009-02-09	No. B.V. :	Révision dessin : D
Prsht Rev. : NC		Matériel : Fibre 7781 et Résine 411-350
Prem. fois : - -	Type :	Date Dûe : 2009-02-16
Job précédente : 43643		Qté: 1 Udm: UNITE


 Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de pièce Dart Aérospatiale: D2445
 N° Delastek Composites: DKC134-0013
 N° de projet Delastek: DK-362

 Process Sheet Rév.: 10 Modification du planning afin d'y inclure le
 N° I.G 0008 (Primer)

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL DART Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006. Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____		
3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
Commentair Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s) Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-26332-1		
4.0	AAC0275	Catalyst N° DDM-9
Commentair Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s) Catalyst N° DDM-9 N° de Lot: 1-22176-1		

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43644

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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5.0	AC0260	Acetone
-----	--------	---------

Commentair Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)
Acetone

6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 21/01/10 Sceau:  Temps Début: 3:15 Temps Fin: 3:30

7.0	GEL COAT.	APPLICATION DE GEL COAT
-----	-----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Date: 21/01/10 Sceau:  Temps Début: 3:30 Temps Fin: 3:45

8.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B

9.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3

10.0	AC0408	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)
Feutre de drainage N° Airweave N 10

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43644

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

11.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)
Stretchlon 200 poche à vide Vert

12.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot: 1-26083-1

13.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR(s)
Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

14.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patterns de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 8/2/06 Heure Début: _____ Heure Fin: _____ Sceau: _____



16.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-22176-1

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43644

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.359 KILOGRAMME(s)/Unit Total : 0.359 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-26248-1

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 22/01/10 Heure Début: 8:00 Heure Fin: 8:05 Sceau:

19.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 22/01/10 Heure Début: 8:05 Heure Fin: 8:20 Sceau:

20.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 22/01/10 Heure Début: 8:20 Heure Fin: 8:40 Sceau:

Curing début: 8:05 Curing Fin: 2:40

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43644Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0042 PINTE(s)/Unit Total: 0.0042 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-22176-1

22.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-26380-1

23.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 22/6/10 Heure Début: 4:00 Heure Fin: 4:25 Sceau:

24.0 AAC0452 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)
Polybond B46F

N° de Lot: 1-25391-1

25.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) #JOB: 43653

26.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 25/6/10 Heure Début: 10:15 Heure Fin: 10:30 Sceau:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43644

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE





Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 25/11/10 Heure Début: 10:30 Heure Fin: 10:40 Sceau:  Curing Début: 10:15 Curing Fin: 4:15

28.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-22176-1

29.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.


N° de Lot: 1-26380-1

30.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 26-11-10 Heure Début: 12:35 Heure Fin: 12:40 Sceau: 

31.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43644

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013



Numéro Job:



Séq.: Machine ou Opération: Description :

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 26-01-19 Heure Début: 12:40 Heure Fin: 1:10 Sceau:  

32.0 POCHÉ À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 26-01-19 Heure Début: 1:10 Heure Fin: 1:20 Sceau:  Curing Début: 12:40 Curing Fin: 8:00

33.0 DÉMOLAGE 1 DÉMOLAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOLAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".

Date: 27-01-19 Heure Début: 8:00 Heure Fin: 8:05 Sceau:  

34.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE COMPOSITES DART

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 27-jan-19 Heure Début: _____ Heure Fin: _____ Sceau:  

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43644

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 AAC0062 Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Label N° D0588-041

Lot: 1-26247-1

36.0 AAC0444 Surface Veil

Commentair Qty.: 0.07 VERGE CAR(s)/Unit Total: 0.07 VERGE CAR(s)

Surface Veil

37.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)

Résine Mia-Poxy

Lot: 1-25679-1

38.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 PINTE(s)/Unit Total: 0.007 PINTE(s)

Durcisseur 95 Pour Résine Mia-Poxy

Lot: 1-25679-2

39.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

FABRICATION GÉNÉRALE DART

Coller le abel N° D0588-041 selon les séquences suivantes:

- 1- Surface Veil
- 2- Label
- 3- Surface Veil

Laisser scher pendant 4 heures.

Date: 1/02/10 Heure Début: 3:45 Heure Fin: 4:00 Sceau:



40.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.025 UNITE(s)/Unit Total: 0.025 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-7129-1

41.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

42.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 2/2/10 Heure Début: 3h15 Heure Fin: 3h45 Sceau:



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43644

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

43.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-25613-2

44.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S


Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S 2-24803-3

45.0 PRIMER APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 29/01/10 Sceau: 

Quantité: 1 Date: 03/02/10 Sceau: 

Quantité: _____ Date: _____ Sceau: _____


Quantité: _____ Date: _____ Sceau: _____

46.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2445.


Date: 4-2-10 Heure Début: 10h15 Heure Fin: 10h30 Sceau: 

47.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 4-2-10 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

Work Order ID 60469

July 12, 2010 11:26:30 AM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 7/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

REMOVE FROM STOCK:
1 X D350-588-041

B 54832

10-7-12

DISASSEMBLE KIT, RETURN ITEMS TO STOCK

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

RE-PACKAGE D2445 DOOR ONLY
FOR S/O 7185 -TEXAS AVIATION

175

QC4- 100% Inspect kits for completeness

0.00



QC

Door B 54832
Memo

0.00

→ 8/10/12

Quality Control

(H)

Work Order ID 60469

July 12, 2010 11:26:35 AM



Page 2

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 7/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1007 12
MF
10-7-12

Picklist Print

July 12, 2010 11:26:17 AM

Page 1

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP PI: 04.02.04 Reformat KJ/DS: IPP Rev:Q as
per DS19414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7 Purchased No



Screw

Location

Loc Qty

Loc Code

ST328

60

113064

9

113749

1

114056

50

155

Each

196.0000

8

-8

AN526C832R8

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

196

114615

96

114718

100

140

Each

146.0000

8

8

AN526C832R9

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST327

146

114341

146

140

Each

0.0000

2

2

AN960JD10

NAS1149D0363J

Purchased

No



Washer

25

N

A

mt 10-7-12

Picklist Print

July 12, 2010 11:26:18 AM

Page 2

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

155 Each 0.0000 2 -2



Washer

AN960JD8 NAS1149DN832 J Purchased No

140 Each 0.0000 8 8



Washer

AN960JD8 NAS1149DN832 J Purchased No

155 Each 0.0000 8 -16



Washer

D2143 Manufactured No

140 Each 17.0000 1 1



Hinge Bracket

Location Loc Qty Loc Code

ST198

17

55323

17

D2144 Manufactured No

140 Each 42.0000 1 1



Hinge Bracket

Location Loc Qty Loc Code

ST198

42

55179

42

D2150 Manufactured No

155 Each 34.0000 2 -2



Packer Doubler, Hinge

Location Loc Qty Loc Code

ST007

34

55178

34

BSS016 SP

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Shop Packet Print

Page 2

Picklist Print

July 12, 2010 11:26:18 AM

Page 3

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

D2151
Packer Doubler, Hinge

Manufactured No

155 Each

19.0000

2

-2



B51407 SP

Location

Loc Qty

Loc Code

ST007

19

55319

19

D2153
Door Prop

Manufactured No

155 Each

38.0000

1

-1



B48373 SP

Location

Loc Qty

Loc Code

ST272

38

55324

2

59818

36

D2154
Stud Bracket

Manufactured No

155 Each

10.0000

1

-1



B44890 SP

Location

Loc Qty

Loc Code

ST007

10

55325

10

D2237
Striker Plate

Manufactured No

155 Each

47.0000

2

-2



B35006 SP

Location

Loc Qty

Loc Code

ST009

47

58181

47

D2445P
AFT DOOR ASSEMBLY

Purchased No

110 Each

0.0000

1

1



10-7-10
A

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Shop Packet Print

Page 3

Picklist Print

July 12, 2010 11:26:19 AM

Page 4

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

D2461 Manufactured No 155 f 257.5242 7.25 -7.25

 Neoprene "D" Seal

sl

Location	Loc Qty	Loc Code
ST402	257.5242105	
39782	6.5	
55054	251.024211	

✓

(D2461-0870) cut (1) at 87.00"
 **** per kit****

D2463 Manufactured No 140 f 291.0818 7.25 7.25

 Seal

Location	Loc Qty	Loc Code
ST404	291.0818105	
43841	3	
50075	11.3536	
55561	276.728211	

N A Mr 10-7-12

(D2463-0870) cut (1) at 87.00"
 **** per kit****

D2585 Manufactured No 140 Each 81.0000 2 2

 Mounting Channel

Location	Loc Qty	Loc Code
ST019	81	
56524	1	
59118	54	
59873	26	

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Shop Packet Print

Page 4

Picklist Print

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Page 5

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

64.0000



Door Latch

2 *N/A*

Location

Loc Qty

Loc Code

ST006

64

57917

64

D2589

Manufactured No

155

Each

205.0000



Keys, Key Chain, 350 Hinge

1 -1 *B47183*
B47183

Location

Loc Qty

Loc Code

ST019

205

58194

205

D2621

Manufactured No

140

Each

76.0000



Latch Plate, 350 Spacepod

2 2

Location

Loc Qty

Loc Code

ST021

76

46842

8

56526

68

D2690-17

Manufactured No

155

Each

4.0000



Cable

1 -1 *B50606*

Location

Loc Qty

Loc Code

ST021

4

58212

4

N/A

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Shop Packet Print

Page 5

Picklist Print

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Page 6

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

D2857-1

 Hinge Bracket

Manufactured No 140 Each 39.0000 1 1

Location

Loc Qty

Loc Code

ST026

39

56529

15

57924

24

MA u

D2857-2

 Hinge Bracket

Manufactured No 140 Each 49.0000 1 1

Location

Loc Qty

Loc Code

ST027

49

55020

5

56530

20

57925

24

D2858-1

 Hinge Bracket

Manufactured No 155 Each 22.0000 1 -1

Location

Loc Qty

Loc Code

ST027

22

55062

1

56423

21

B45798 SP

D2858-2

 Hinge Bracket

Manufactured No 155 Each 14.0000 1 -1

Location

Loc Qty

Loc Code

ST027

14

56048

14

B45799 SP

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Shop Packet Print

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Picklist Print

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Page 7

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

155 sf

2,198.000 1 -1



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

ST404

2198

108932

18

111166

405

113905

1775

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155 Each

6,548.000 12 -12



RIVET

Location

Loc Qty

Loc Code

ST316

6548

104374

2548

110398

4000

MS20470AD4-5

Purchased

No

155 Each

1,431.000 18 -18



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

1366

114761

1366

ST319

65

111916

65

MS21042L08

Purchased

No

140 Each

229.0000 8 8



Nut

Location

Loc Qty

Loc Code

ST300

229

114330

29

115016

200

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Shop Packet Print

Page 7

Handwritten notes and signatures:
 - Next to ST404: *rsf*
 - Next to ST316: *12 sf*
 - Next to ST319: *18 sf*
 - Next to ST300: *N*
 - Large signature: *MF 10-7-12*
 - Stamp: *1113749*

Picklist Print

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Page 8 / 19

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

155

Each

229.0000

8

-10



Nut



M113749 SP

Location

Loc Qty

Loc Code

ST300

229

114330

29

115016

200

MS21042L3

Purchased

No

140

Each

2,692.000

4

2



Nut



M112385

Location

Loc Qty

Loc Code

ST300

2692

114523

216

114718

476

114784

2000

MS21042L3

Purchased

No

155

Each

2,692.000

4



Nut



VAL

Location

Loc Qty

Loc Code

ST300

2692

114523

216

114718

476

114784

2000

MS27039-08-11

Purchased

No

155

Each

69.0000

2

-2



Screw



M111977 SP

Location

Loc Qty

Loc Code

ST288

50

114382

50

ST290

19

113749

19

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Shop Packet Print

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Picklist Print

July 12, 2010 11:26:29 AM

Page 9 19

Work Order ID: 60469

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 7/12/10

Required Date: 7/12/10

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

140

Each

113.0000

2

2



Screw

Location

Loc Qty

Loc Code

ST292

113

114056

13

114718

100

N/A

July 12, 2010 11:26:29 AM

Shop Packet Print

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